Work Orde December 7, 200	r ID 54275 9 1:17:27 PM						;				Page
	D3838-042		1	Accept				S	Setup Start	! [52][[6] 1]	
Item Name:	Rib Assembly (Basket Lid 07/12/2009	y: 2.00			Cust Item II Customer:	):		13 14.	Stop		1116 HA HAN 1881
Reference: Approvals:	Process Plan:QC:		Date: <u>54/2-7</u>	Tooling: SPC (Y/N):	Da			. I	Run Star Stop		
Sequence ID/ Work Center II	Operatio D Descripti			Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr Rev A			0.00						1	
Large Fab	Large Fab		38-2 and D3838-3 rib as per ole as per dwg	0.00	) 09-12-23		·	·2			
		3- remove	identification markings								

5- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838
A/R ER316 S.S. Rod Batch: 竹いの名から

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

4- deburr

8-Grind flush

3

PD 10.01.05

<b>Dart Aerosp</b>	ace Ltd
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Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: NCR: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Corrective Action Section B											
Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:	W/O:			WC	ORK ORDER CHA	NGES		· · · · · · -			
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE   STEP   Description of NC	DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Chief Eng /	Approval QC Inspector
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE   STEP   Description of NC											
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE   STEP   Description of NC			,								
Resolution:Disposition:QA: N/C Closed:Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Approval Initial Action Description Sign & Section C Chief English											à
Resolution:Disposition:QA: N/C Closed:Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Approval Initial Action Description Sign & Section C Chief English											. ,
Resolution:Disposition:QA: N/C Closed:Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Approval Initial Action Description Sign & Section C Chief English	Part No:	:	PAR #:	Fault Cate	gory:	NCF	R: Yes	No <b>DQ</b>	A:	Date: _	
DATE STEP Description of NC Section A Section B Section B Verification Approval Initial Action Description Sign & Section C Chief Eng.											
DATE STEP Description of NC Section A Initial Action Description Sign & Verification Approval Section C Chief Eng	NCR:			WORK ORD	ER NON-CONFOR	RMANCE	(NCR	)			- ç. · w
Section A Initial Action Description   Sign &   Section C   Chief Eng	DATE	CTED	Description of NC	ļ			****	Verific	cation	Approval	Approval
	DATE	SIEP			Action Descripti Chief Eng	ion					QC Inspector
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	•										
						A-7-7-1-1-1-1					

## Work Order ID 54275



Page 2

December 7, 2009 1:17:27 PM

Required Date: 11/12/2009

Item ID:

D3838-042

Accept



Setup Start



**Revision ID:** 

Item Name:

Rib Assembly (Basket Lid, RH)

Starg Date:

07/12/2009

Start Qty: 2.00

Req'd Qty: 2.00

Operation

Description



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date: Date:\_

Stop

Stop



Sequence ID/

Work Center ID

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Draw

Number

Plan Draw Code Rev.

Accept Qty

Reject Qty

Run

Reject Insp. Number Stamp

110

Quality Control

Memo

OC5- Inspect part completeness to step on W/O

0.00

120

Large Fab

Large Fab

Large Fab

0.00

0.00

1- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open

A/R ER316 S.S. Rod □2- grind weld flush where indicated on dwg D3838

weld D3759-1 bushing as per dwg D3838 □4-

130

QC

Memo

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

Quality Control

Dart Aerospace I	Ltd
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<b>-</b> u	Johnson	Liu							
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	Re	esolution:	Disposition	•	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	0750	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
									:

## Work Order ID 54275



Page 3

December 7, 2009 1:17:27 PM

Item ID:

D3838-042

Accept

Setup Start

 $\mathcal{G}_{n} \subset \mathcal{G}_{n}^{*}$ 

Stop



**Revision ID:** 

Item Name:

Rib Assembly (Basket Lid, RH)

Start Date: 1-

07/12/2009

Start Qty: 2.00

Reg'd Qty: 2.00



**Cust Item ID:** 

**Customer:** 

Draw

Number



Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Run Start

Stop



**Required Date:** 11/12/2009

QC: \_\_\_\_\_ Date:\_\_\_\_

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Draw

Rev.

Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

Operation **Description** 

OC5- Inspect-part completeness to step on W/O

0.00

0.00

150

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

10.01.08

Packaging

Memo

Memo

160

Quality Control

OC21- Final Inspection - Work Order Release

0.00

0.00

BS10-1-08 (2)

## **Dart Aerospace Ltd**

W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								.,	
Part No	:	PAR #:	Fault Categ	gory:	_ NCR: Ye	s No DC	A:	Date: _	
	R	lesolution:	Disposition	n:	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip		ion B Sigr		cation tion C	Approval Chief Eng	Approval QC Inspector
<b>4.</b>		OCCIONA	Chief Eng	Chief Eng	Dat		uon C	Chief Eng	QC inspector

# **Picklist Print**

December 7, 2009 1:17:33 PM

Work Order ID: 54275

D3838-042

Parent Item:

Parent Item Name: Rib Assembly (Basket Lid, RH)

Comments:

IPP rev B 09.11.24 updated process EC verified by DD



Start Date: 07/12/2009

Required Date: 11/12/2009

Page 1

Start Qty: 2.00

Required Qty: 2.00

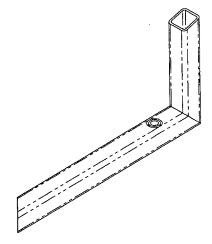
Component Item ID/; Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Late Issued	Status
D3759-1		Manufactured	No		-	100	Each	10.0000	2.0000			
Bushing				Warehou	<u>se</u>	Loc (	Qt <u>v</u>	Loc Code	<b> </b>			
				Loca	tion				4			
				Main Wa	ehouse							
				WA			10		_	<u>-</u> -		
					53442		10	B 540	אם פנג	D 10.01.05	_	
M304TS0.750W.065		Purchased	No			120	f	438.2178	2.1720	SAD te	09-	#2- 2°

304 SQ Tube .75x.75x.065W

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
MAT	438.2177742		
113082	36.90419		
113245	401.313584		2,1720
Main Warehouse			
WA	0.0000047		
112398	0.0000047		

Dari Ae	rospace	# Lia							,
W/O:			WO	RK ORDER CHANGES	)			<del></del>	
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	):	PAR #:	Fault Categ	gory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
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NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR	)			
DATE	CTED	Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

QTY QTY -041 -042 ITEM P/N DESCRIPTION RIB ASSY (BASKET LID, LH) D3838-041 1 X D3838-042 RIB ASSY (BASKET LID, RH) 2 D3759-1 BUSHING 3 5 D3838-1 RIB D3838-2 RIB RIB D3838-3

D

SHOP COT Y REIUBNOO ENGINEERICG UNCONTRO! 1 -11 C SUBJECT TO AND NOT WITHOUT NOW FOR PORT NO. 54275.

RA 09-12-7

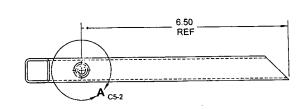
A	NEW ISS	SUE (		МВ	08.10.08					
REV.			DESCRIPTION	BY	DATE					
DESIG		-	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
CHECK		MSS	DRAWING NO.	REV. A						
APPRO	OVED	200	RIB ASSY (BASKET LID)							
DE AP		0.08	COPYRIGHT © 2008 BY DART AE  THIS DOCUMENT IS PRIVATE AND COMPENSATION AND IS SUPPLIED ON THE BURGET OF COMMENSATION OF THE BURGET OF THE BURG	ROSPAC IN THE EXPRE	\$\$ CONDITION THAT IT IS					

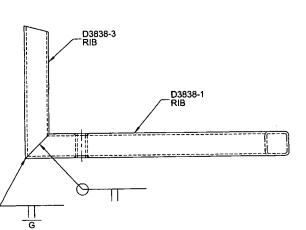
OTES:
) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
3) UNITS: INCHES UNLESS OTHERWISE NOTED
3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
3) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs

5

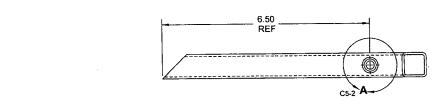
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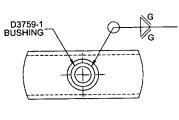
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W/O:			W	ORK ORDER CHANGE	ES				
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		Description of NC		Corrective Action Section	on B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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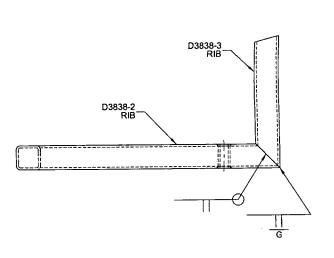


D3838-041 RIB ASSY (BASKET LID, LH)





DETAIL A D7-2 SCALE 2X



### D3838-042 RIB ASSY (BASKET LID, LH)

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D3838 DESIGN DRAWN REV. A CHECKED MFG. APPR. SHEET 2 OF 3 TITLE SCALE APPROVED RIB ASSY (BASKET LID)

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THIS DOCUMENT OF PRIVATE AND COMPETITION AND SUPPLIED ON THE DIVISES OFFORT
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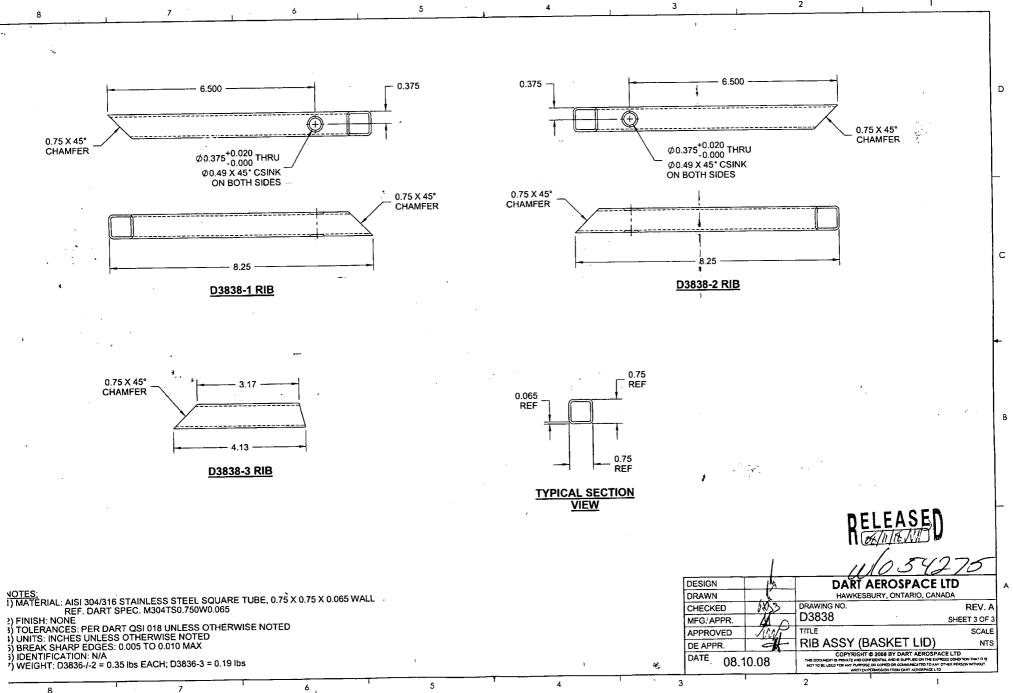
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Dart Ae	rospace Ltd									
W/O:			WORK ORDER CHANGES							
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Part No	):	PAR #:	Fault Category:		NCR: Yes	No DQ	<b>A</b> :	_ Date: _		
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